

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004263**Date Inspected:** 22-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shangxing Island, Shanghai

CWI Name:	N/A			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Deck panel**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China.. While on site the QA Inspector noted the following:

Deck Panel DP42-2

The QA Inspector performed Ultrasonic Testing (UT) on the partial joint penetration welds made on the U-ribs (four ribs two welds per rib eight total welds) on the deck panel identified as DP42-2. The QA Inspector performed the ultrasonic testing using the gate to gate technique on the tack weld areas only a total of 224 tack welds were made on the eight welds. The QA Inspector performed the testing on the weld number one through eight. The QA Inspector observed several linear indications from the total tested welds at random locations and the indications were marked on the steel for phased array ultrasonic testing investigation that will be performed at a later time. The QA Inspector did not complete the testing on these welds at this location on this date due to fact that the QA Inspector was requested to be present at the confined space training during this shift on this date. The QA Inspector did not record the indication's location observed on the QA Inspector's log. The QA Inspector notified Task Leader Robert Cuellar and Albert Carreon of indications observed and the status of the uncompleted testing.

Summary of Conversations:

None of major significance.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
